

Date: Thursday, 25/01/2007 1:40:32 PM  
 User: Linda Lacelle

## Process Sheet

*split 8B 07/03/29*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DUMP OUTLET
Job Number : 30470	
Estimate Number : 12131	
P.O. Number : <i>N/A</i>	Part Number : D34757
This Issue : 25/01/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3475 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27543	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 01/02/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-01-31 JLM Est Rev:B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



*ASAP*

Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2945* For D3475-7S

Spin as per Dwg D3475

Possible Supplier: SIEG

Material release note is required

*CD 07/01/25*

*(10)*

2.0 D34757S SCOOP OUTLET SPINNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
scoop outlet

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

*07/01/31*

*[Signature]*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*07-02-06*

*(10)*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Scribe line at .180" Below center line of part

*FF 07-02-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 25/01/2007 1:40:32 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 30470

Part Number: D34757

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Rough Cut Part on Band Saw Leaving some Material.

FF 07-02-08

10

3-Using DT8842 Angle Block, Sand Part on Disk Sander to Scribed line.

FF 07-02-08

10

4-Transfer Punch Using DT8843, Then Drill as per Dwg D34757

07-05-02

5-Deburr.

Permanent Change

~~FF 07-02-08~~ 10

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10 07-05-02 @

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07-05-02 @

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 07-05-02

Job Completion



10 07-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

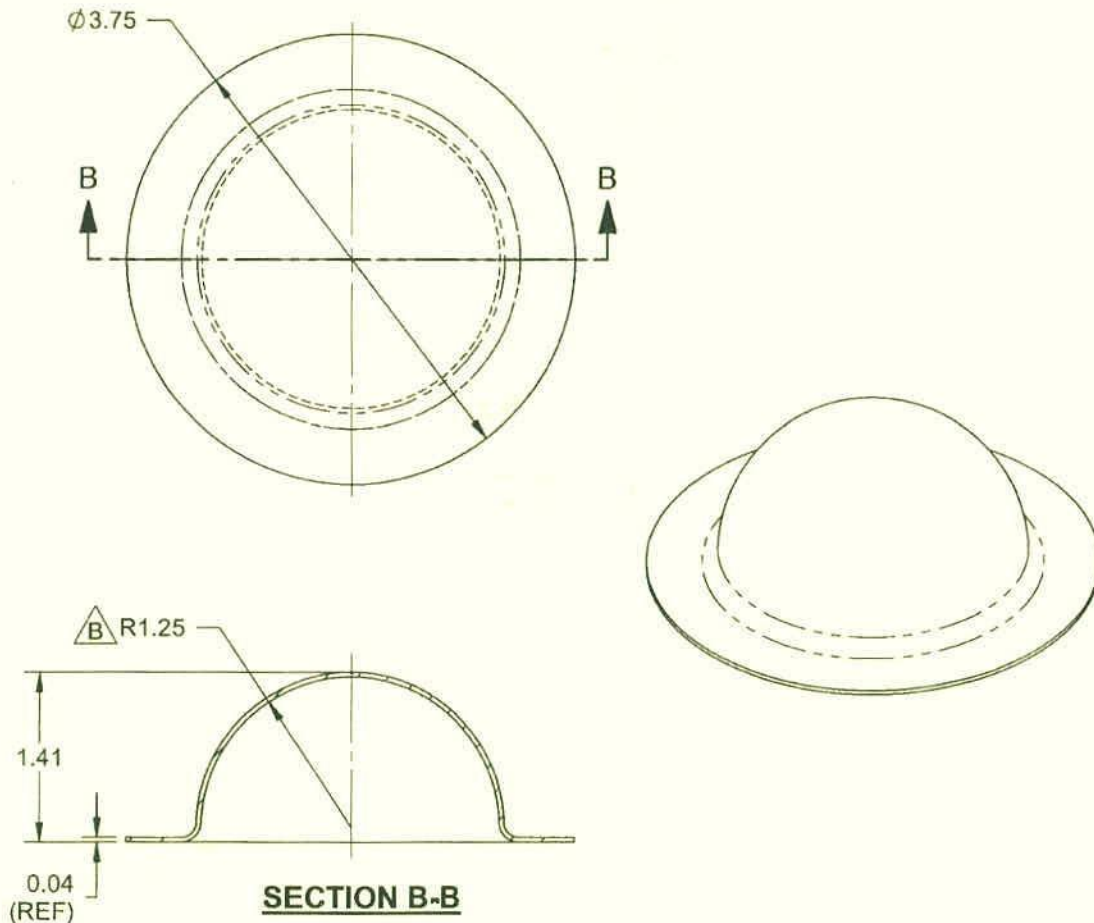
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3475	REV. B SHEET 5 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

**RELEASED**  
06.05.16 H**D3475-7S SCOOP OUTLET, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4  
OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

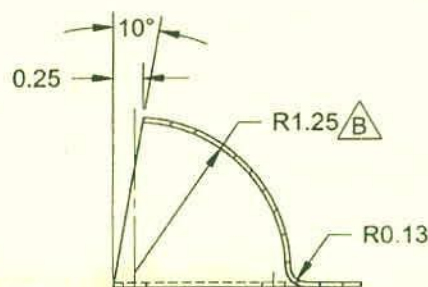
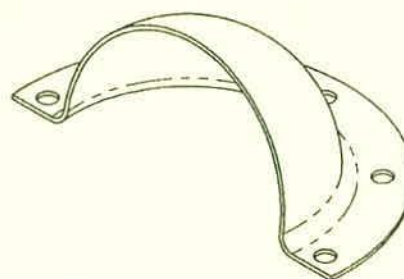
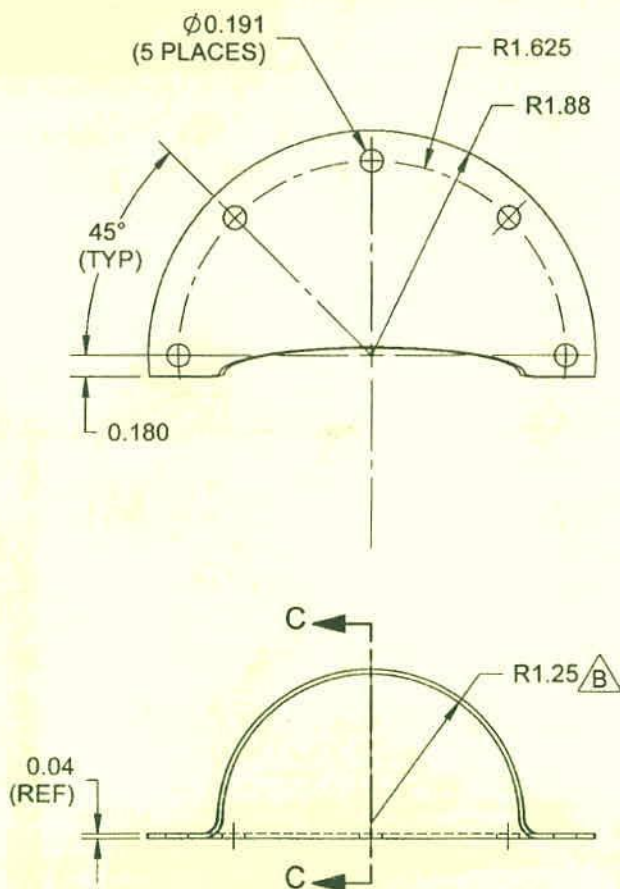
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3475</b>	REV. B SHEET 6 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:1.5

**RELEASED**  
*06.05.16***SECTION C-C****D3475-7 SCOOP OUTLET****NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES  $0.005$  TO  $0.010$

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

## INSPECTION REPORT

DATE: Jan. 24 07

CUSTOMER: DART

INVOICE #: \_\_\_\_\_ SUPPLIER #: P000002945

DESCRIPTION OF INSPECTION: check size, metal.

<u>PART #</u>	<u>QTY.</u>	<u>MATERIAL</u>	<u>CHECK HOLES</u>	<u>DEBUR EDGES</u>	<u>INSP BY.</u>
<u>D3475 Rev B</u>	<u>10</u>	<u>2024.040</u>	<u>✓</u>	<u>✓</u>	<u>JK</u>

NOTES OF INSPECTION: \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

NOTES OF REJECT: \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_





CUSTOMER 02510		SHIP DATE 02/17/06 SHP		GROSS WEIGHT 211		QUOTE 38-259436-1		OF 1		PACKING LIST	
BILL TO SIEGS MANUFACTURING LTD.		WORK ORDER **		ORDER DATE 02/03/06 ORD		DELIVERY DATE 02/17/06 DEL		SHIP BRANCH 38(17)		TEST RESULTS	
SHIP TO SIEGS MANUFACTURING LTD. 6236 - 205 STREET LANGLEY BC CANADA		V2Y 1N7		01		19044 95A AVENUE, SURREY BRITISH COLUMBIA, CANADA V4N		Copper and Brass Sales Canada		UY2370	
CUSTOMER P.O. NUMBER ARLA		TERRITORY 02		ENTRY ID 38JJD		CUSTOMER SIGNATURE		DATE			
BUYER ARLA		INSIDE SALES JOE J. DILIELLO		QUANTITY		ORDERED		SHIPPED			
BUYER TELEPHONE (604) 530-7455		INSIDE SALES TELEPHONE (604) 882-3493 229		INVENTORY		26.78 LB		27.00			
SHIP VIA		SHIPPING STATUS		BILLING		1.00 PC		1.00			
INTERNAL		COMPLETE X		PARTIAL		CANCEL		WAREHOUSE			
TO CUSTOMER COMMON/FRT-BESTWAY		FOB ORIG		PACKED WITH OTHER GOODS							
BILL OF LADING		FREIGHT STATUS PPD		FINISHED GOODS LOCATION		WARN LABEL:1005					
		PART DESCRIPTION				752603-1					
AIRCRAFT QUALITY 2024-O CLAD ALUM SHEET, .040 X 48 X 144 -SIEGS MANUFACTURING LTD. ***, NO PROCESSING - 48" X 144" Mill Dimensions., PVC Clear 1 Side. Test Results Attn to: QA Department. , **ok to ship as per P Walsh **all sheets, must be squared and flat on each skid-please ensure each skid has 2 X 4 , legs cut and placed on bottom of skid (along 48" width) for easy forklift , access. **each size to be sep. on indiv.											
SPECIAL INSTRUCTIONS											
FULL		SCRAP		FILLED BY USA		PACKED BY		QA AUDIT			
CUSTOMER RECEIVING HOURS 7-3:30pm, avoid 11:3		MAX SKID WEIGHT 3000		LOADING INSTRUCTIONS FORK		MAXIMUM BLANK WEIGHT 3000					
BOXES		BARS		CASES		CUSHIP		PKGS		SKIDS	
								1		BOLS	
										TUBES	
										CTNS	
										FLAT	
										COILS	
INSPECTION RECORD											

### TEST RESULTS

#### CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.  
The products we distribute are not hazardous in their received state. For MSDS sheets go to [www.copperandbrass.com/msds](http://www.copperandbrass.com/msds)  
or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

00-A-250/5

AMS 4040

ASTM-B209

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT  
1.00 PC ALCOA I 08G6265 533531

PCS TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

DAVID K. BARESH

- General Manager: VANCOUVER

PRINTED 02/15/06 03:13 PM

CONTROL NO 00082

COPPER AND BRASS SALES CANADA IS A DIVISION OF THYSSENKRUPP MATERIALS, CA. LTD./LÉ





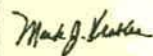
## CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition tests and had the mechanical properties shown on the face of this sheet.



Mark J. Vrabec  
Director of Manufacturing Davenport Works



Kerton P. Young  
Quality Assurance Manager

205131  
Ship Date9050  
B.L. No.

Invoice No.

Alcoa No. Item

Page 1

2003-01-10

24546

56912

DS-56734-1

P.O. No./Govt Contract No.

Customer

8G6265

C&amp;B-WALLINGFORD

Ship To: COPPER & BRASS SALES INC  
WALLINGFORD BRANCH  
5 STERLING DRIVE  
WALLINGFORD, CT 06492

## Item Description

.040 IN TH (+.0000 -.003) X 48 IN W X 144  
IN LN (N) A/T ALCLAD 2024-O FLAT SHEET MILL FINISH (PART 752603-  
1) RAMMA 02-182-030, PER (EXC GA TOL) AMS-QQ-A-  
250/5 REV A & EXCEPT MARKING  
ASTM B209 REV 02 & EXCEPT MARKING AMS 4040 REV H  
(MARKED) INTERLEAVED MAX GROSS  
SKID WGT: 2400 LB QUAN TOL +/-30 %  
CQR 0137587 REV 01 QRR 000879 CUST REQ 02-12-  
15 \*\*\* W/E 02-12-21 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	639714	533531	2035	77	PC	
2	639810	533531	795	30	PC	
3	639812	533531	2011	77	PC	
4	639813	533531	2115	81	PC	
5	639814	533531	2039	77	PC	
			8995	342		

Notes for CQR: 0137587.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/5 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2.

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/5.

CQR: 0137587.1 -Specification Limits

Temp	Dir		UTS	TYS	EL4D
O	Long Transv.	Max	KSI	KSI	PCT
		Min	30.0	14.0	12
			UTS	TYS	EL4D
Temp	Dir		KSI	KSI	PCT
T42	Long Transv.	Max			
		Min	57.0	34.0	15
			UTS	TYS	EL4D
Temp	Dir		KSI	KSI	PCT
T42P	Long Transv.	Max			
		Min	57.0	34.0	15

C & BS  
Q.C. APPROVED  
17-8

SIKORSKY





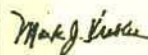
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Mark J. Vrabec  
Director of Manufacturing Davenport Works



Kerton P. Young  
Quality Assurance Manager

205131

9050

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

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2003-01-10

24546

56912

DS-56734-1

P.O. No./Govt Contract No.

Customer

8G6265

C&amp;B-WALLINGFORD

CQR: 0137587.1 -Specification Limits (cont.)

Temp	Dir	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	Max		
		Min	60.0	47.0 5

Chemical Composition	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	Each	Total	Aluminum
Alloy 2024	Min	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15			
				3.8	.30	1.2								REMAIN

Chemical Composition	Max	SI+PE	CU	MN	MG	V	ZN	TI	Other	Aluminum
LINER	Min	.70	.10	.05	.05	.05	.10	.03	.03	
Alloy 1230										99.30

Lot: 533531 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
0	Long Transv.	2	Max	23.4	11.5 20
			Min	23.4	11.4 20

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42	Long Transv.	2	Max	60.8	37.6 24.5
			Min	60.5	37.5 19.5

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42P	Long Transv.	2	Max	52.5	38.4 27
			Min	52.4	38.2 25

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	2	Max	61.8	49.4 9.5
			Min	61.6	48.9 9





## CERTIFIED INSPECTION REPORT

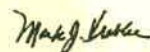
Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

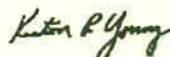
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Per



Mark J. Vrabec  
Director of Manufacturing Davenport Works



Keston P. Young  
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DS-56734-1

Customer

8G6265

C&amp;B-WALLINGFORD

Page 3

Lot: 533531 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9532015	Actuals	.07	.17	4.6	.64	1.6	.01	.10	.03

